

Date: Monday, 6/12/2006 2:27:38 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 212 BASKET BASE ASS'Y LH
 Job Number : 27487B
 Estimate Number : 11543
 P.O. Number : *NIA*
 This Issue : 6/12/2006 S.O. No. : *NIA*
 Prsht Rev. : NC
 First Issue : *NIA* Type : LARGE FAB ASSY
 Previous Run : *NIA*
 Part Number : D3053042
 Drawing Number : D3053 REV A
 Project Number : *NIA*
 Drawing Revision : A
 Material : *NIA*
 Due Date : 6/19/2006 Qty: 1 Um: Each
 Written By : *SEE COMMENT BELOW*
 Checked & Approved By : *PA 06.06.12 W*
 Comment : Est. C 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 45.5000 f(s)/Unit Total : 45.5000 f(s)

304 SQ Tube.75x.75x.065W

Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: *M10111*

06/06/12

2.0 D31661 Basket Hoop



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Basket Hoop

Cut

Qty. 5 D3166-1

Batch: *B27326*

06/06/12

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Drill holes in D3053-3 as per Dwg D3053

06/06/16

4.0 D23273 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Pick:

Qty Part Number

Description

Batch

2 D2327-3

Bushing

B27051

06/06/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 2:27:38 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y LH

Job Number: 27487B

Part Number: D3053042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Pick:

Qty Part Number Description
2 D2232-3 Hinge plate

Batch

B24527

06/06/16

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Pick:

Qty Part Number
2 D2581

Description

Mounting Bracket

Batch

B 262041

06/06/16

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 50.4000 sf(s)/Unit Total : 50.4000 sf(s)

Expanded Metal Flat Stai

Pick:

Qty Part Number
48sq.ft M304EX0.75-16F

Description

Expanded Metal

Batch

B 100781

06/06/16

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Remove all markings from material

Drill holes in three D2235-3 ribs as per Dwg D3053 using Jig DT8365

Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

****Ensure ribs are positionned for LH****

06/06/16

9.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

06-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 26/06/23

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/12/2006 2:27:38 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y LH

Job Number: 27487B

Part Number: D3053042

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Take Traveller D205-541-043 to KP

DL 06/06/14 (1)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DL 06/06/14 (1)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Job 06.22 (1)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: B 27487

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/06/14 (1)

Job Completion



u 06.06.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

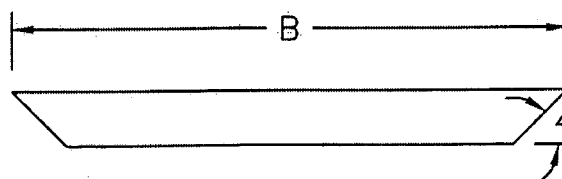
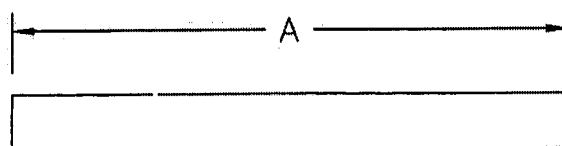


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3053	REV. A SHEET 1 OF 3
DATE 01.11.01		TITLE BASKET BASE ASSEMBLY (212)	SCALE NTS
A	01.11.01	NEW ISSUE	

RELEASED
01.12.20 #

PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	—	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



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WORK ORDER

NO. 274887B

NOTES:

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

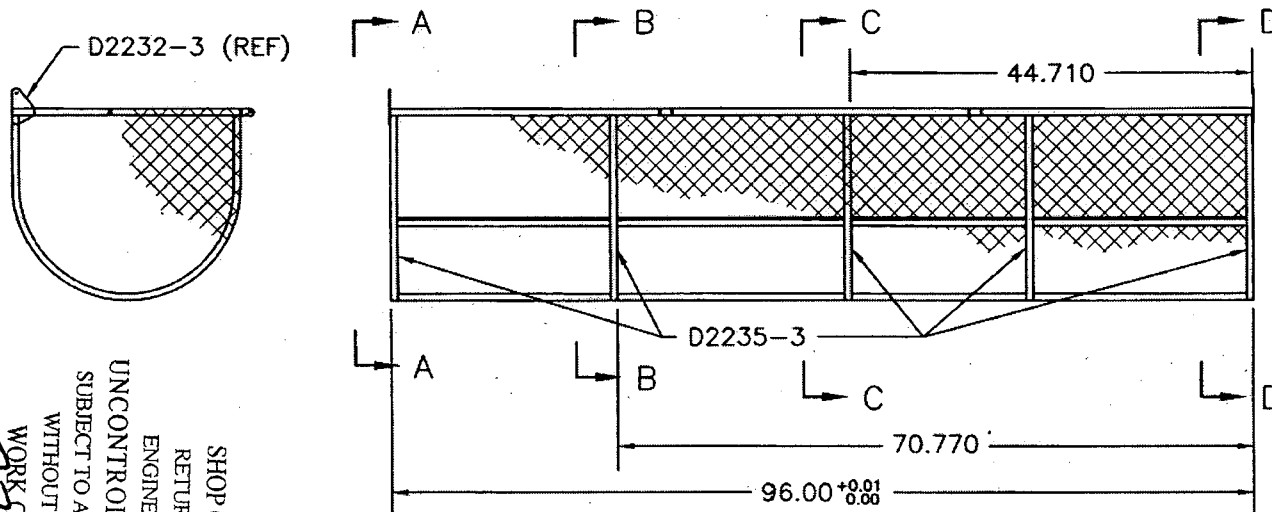
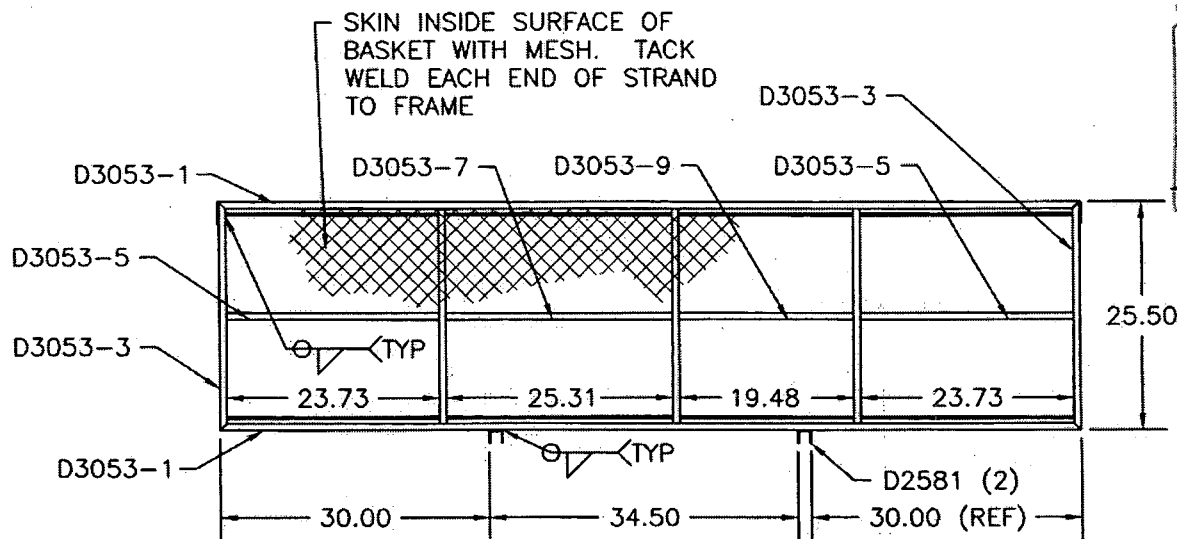
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d 12 20 97

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	01.11.01	DRAWING NO.	D3053	REV. A
		TITLE	BASKET BASE ASSEMBLY (212)	SHEET 2 OF 3
				SCALE 1:20

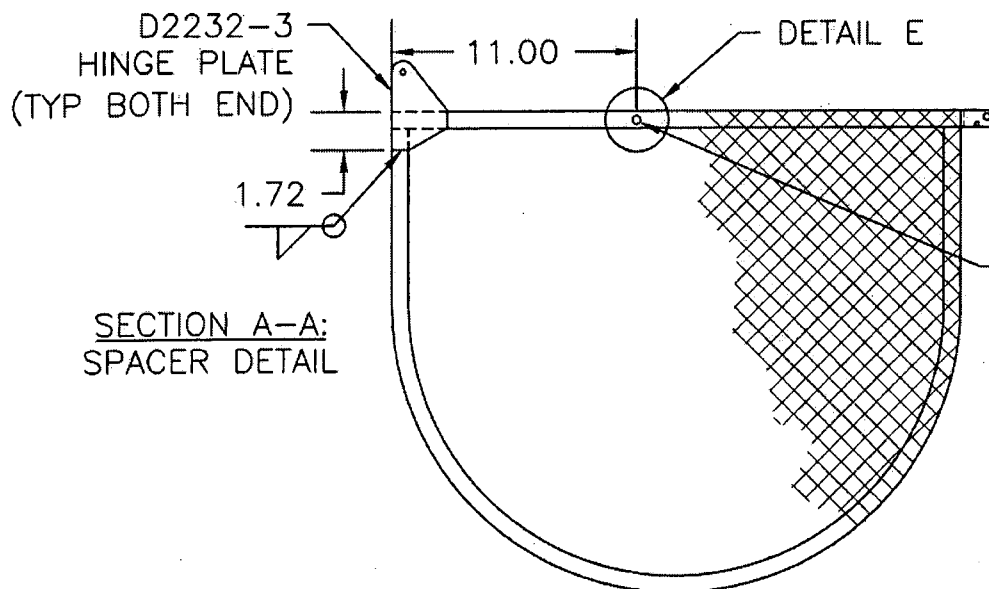


D3053-042 BASKET BASE ASSEMBLY SHOWN
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)

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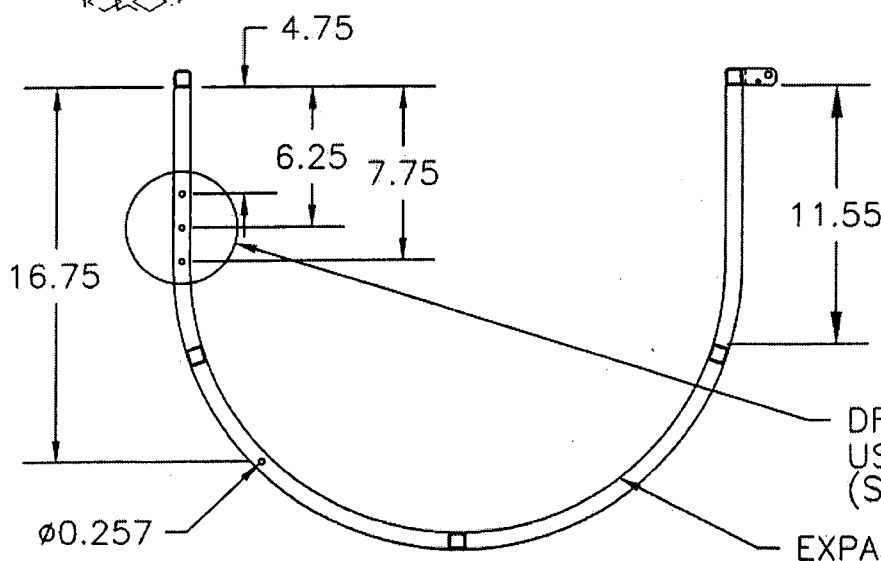
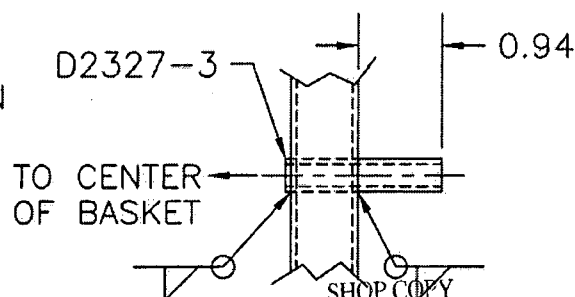
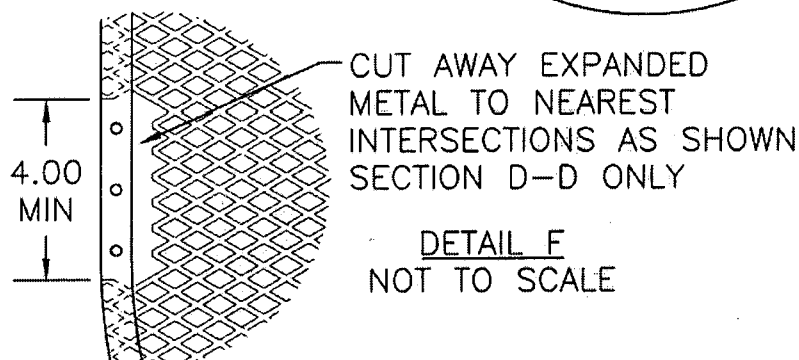
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A	APPROVED H	DRAWING NO. D3053	REV. A SHEET 3 OF 3
DATE 01.11.01		TITLE BASKET BASE ASSEMBLY (212)	SCALE 1:8



RELEASED
01.12.20

SECTION A-A:
SPACER DETAIL

DRILL 3/8 HOLE
AND INSTALL
D2327-3 USING
CLOSEST SPACE IN
EXPANDED METAL
FOR HOLE LOCATION
BOTH ENDS



SECTION B-B,
SECTION C-C AND
SECTION D-D:
RIB DETAIL

DRILL 0.257 DIA HOLES
USE DRILL JIG T2489DJ
(SEE DETAIL F)

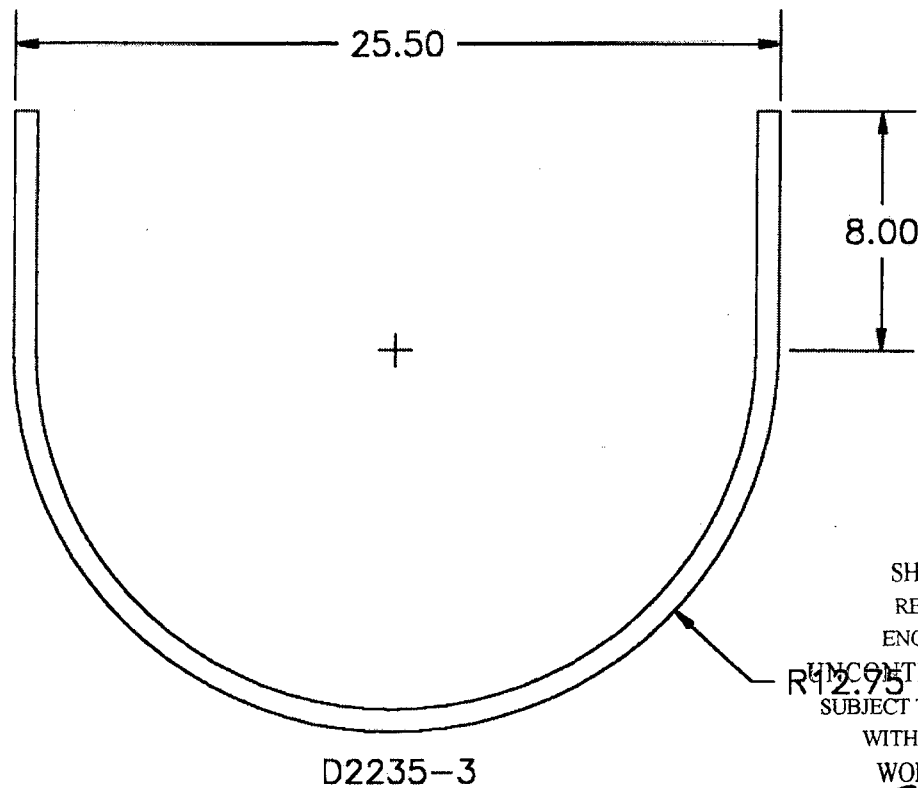
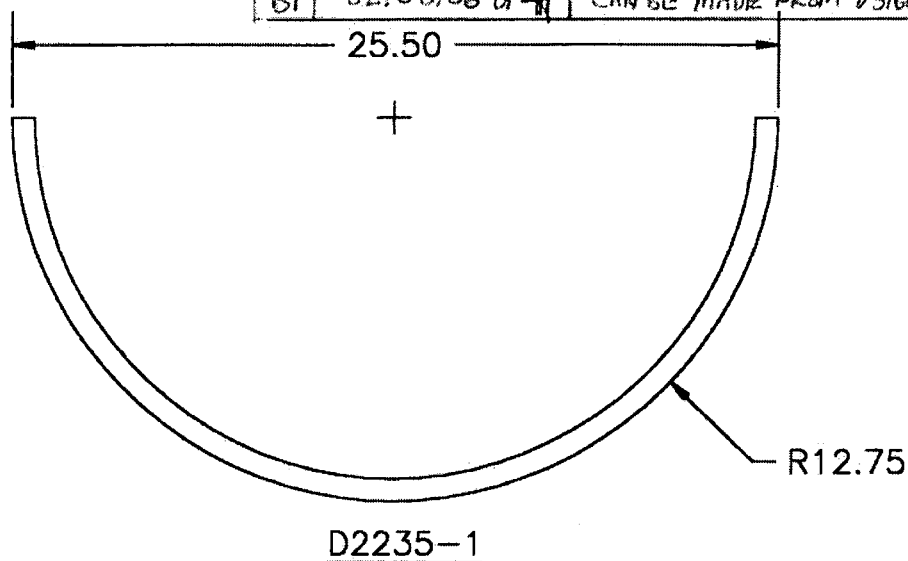
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DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	
BI	02.08.06 <i>[Signature]</i>	CAN BE MADE FROM D3166-1	

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R 960507



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NO. **27487B**

CAN BE MADE FROM D3166-1 *[BI]*
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.